

# Work Order ID 66808

Monday, February 28, 2011 10:25:20 AM



Page 1

Item ID: D3065-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Step Leg Assembly Hi					
Start Date: 2/28/2011	Start Qty: 20.00		Cust Item ID:		
Required Date: 3/7/2011	Req'd Qty: 20.00		Customer:		
Reference:					

Approvals:	Process Plan: <i>AK</i>	Date: <i>11-02-28</i>	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3065	Rev B

100		0.00
	Small Fab	
Small Fab	Memo	0.00
Small Fab	Assemble as per Dwg D3065 and Identify as D3065-041	

*354/03/14 20*

110	QC5- Inspect part completeness to step on W/O	0.00
QC	Memo	0.00
Quality Control		

*8 uloz 115*

*counted*  
*720*

120	Identify as per dwg & Stock Location: <i>WA</i>	0.00
Packaging	Memo	0.00
Packaging		

*AK 11.03.18*

*20* *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 66808**

Monday, February 28, 2011 10:25:20 AM



Page 2

Item ID: D3065-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Step Leg Assembly Hi

Start Date: 2/28/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 3/7/2011 Req'd Qty: 20.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00




QC

Memo

0.00

Quality Control

11/3/21   
CL11103121

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**NOTE:** Date & initial all entries

# Picklist Print

Monday, February 28, 2011 10:25:28 AM

Page 1

Work Order ID: 66808

Parent Item: D3065-041

Parent Item Name: Step Leg Assembly Hi





Start Date: 2/28/2011

Required Date: 3/7/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev: C02.11.01 Incorporated D3066-1 IPP KJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3065-1  Step Spacer		Manufactured	No			100	Each	50.0000	1	20			
<div> <div>Location</div> <div>GA</div> <div>65549</div> </div> <div> <div>Loc Qty</div> <div>50</div> <div>50</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3065-3  Step Spacer		Manufactured	No			100	Each	43.0000	1	20			
<div> <div>Location</div> <div>GA</div> <div>65551</div> </div> <div> <div>Loc Qty</div> <div>33</div> <div>33</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3065-5  Step Leg		Manufactured	No			100	Each	28.0000	2	40			
<div> <div>Location</div> <div>GA</div> <div>65552</div> </div> <div> <div>Loc Qty</div> <div>28</div> <div>28</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3065-7  Step Spacer		Manufactured	No			100	Each	20.0000	1	20			
<div> <div>Location</div> <div>GA</div> <div>65550</div> </div> <div> <div>Loc Qty</div> <div>20</div> <div>20</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

*EJS 4/03/11*

*20*  
*EJS 4/03/11*

*20*

*EJS 4/03/11*

B66971 (120)

*28*  
*EJS 4/03/11*

*20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Monday, February 28, 2011 10:25:28 AM

Work Order ID: 66808



Parent Item: D3065-041



Parent Item Name: Step Leg Assembly Hi

Start Date: 2/28/2011

Required Date: 3/7/2011

Start Qty: 20.00

Required Qty: 20.00

MS20470AD4-4

Purchased

No

100

Each

3,080.000

30

600



Rivet, Universal Head



*Handwritten signature and date: 2/28/11*

Location

Loc Qty

Loc Code

ST319

3080

112314

30

113368

92

116188

642

116391

2316

*Handwritten 600*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

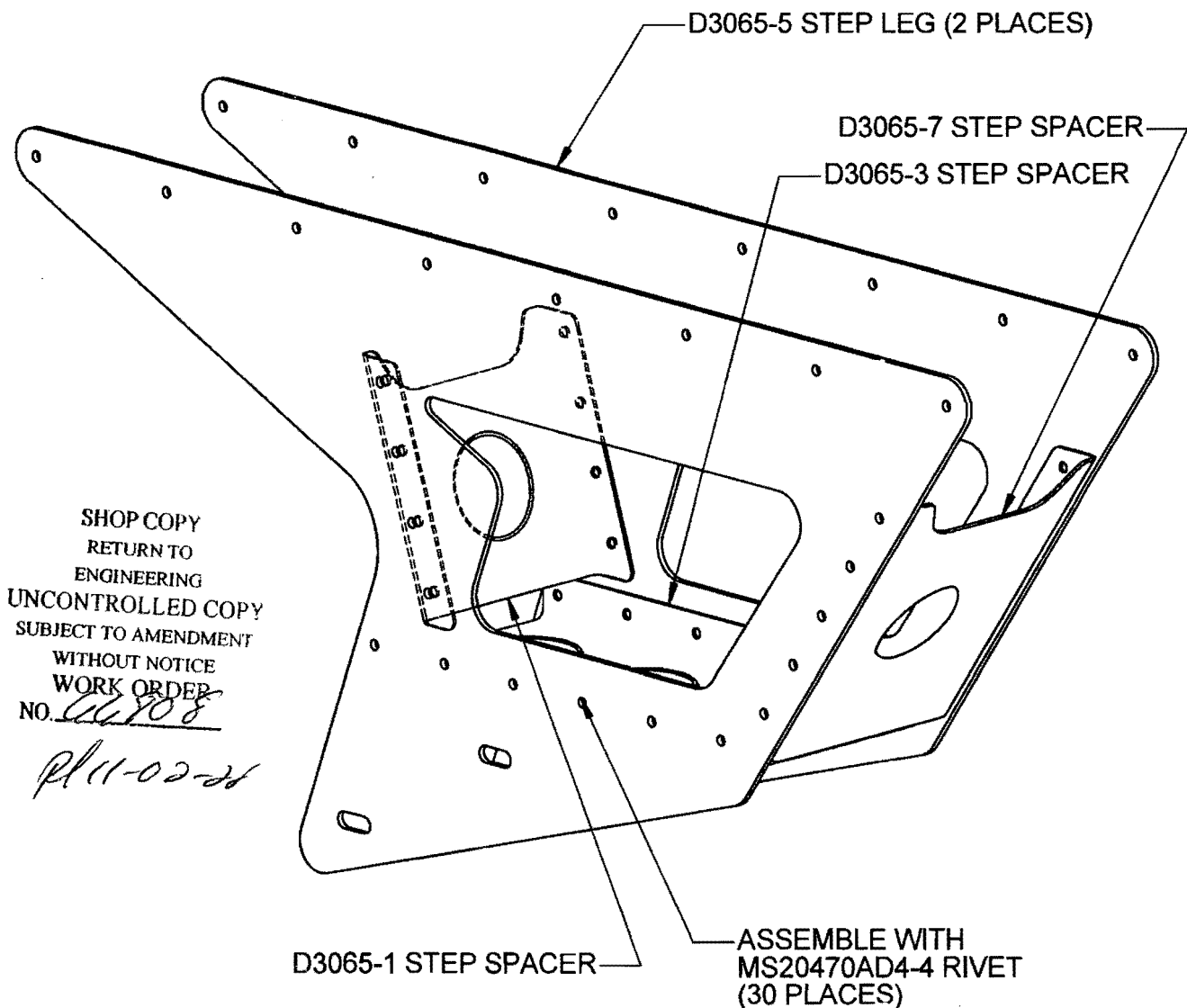




DESIGN <i>CP</i>	DRAWN BY <i>C.B.</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3065	REV. B SHEET 1 OF 5
DATE 06.05.23	TITLE STEP LEG ASSEMBLY		SCALE 1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

*06.06.20* *[Signature]*



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *66808*

*PL11-02-28*

## D3065-041 STEP LEG ASSEMBLY

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

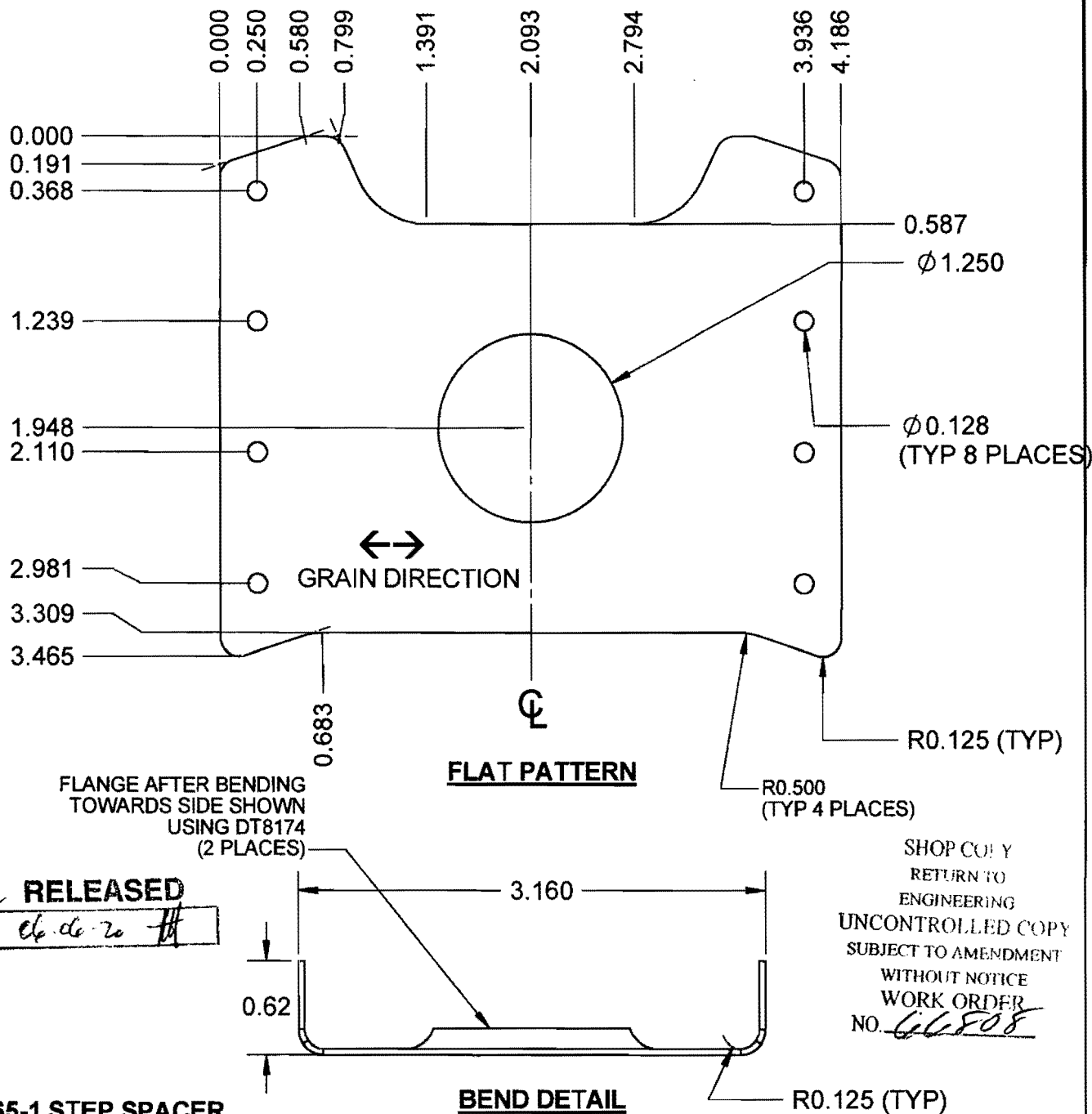
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 2 OF 5
DATE <b>06.05.23</b>		TITLE <b>STEP LEG ASSEMBLY</b>	SCALE 1:1



### D3065-1 STEP SPACER

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

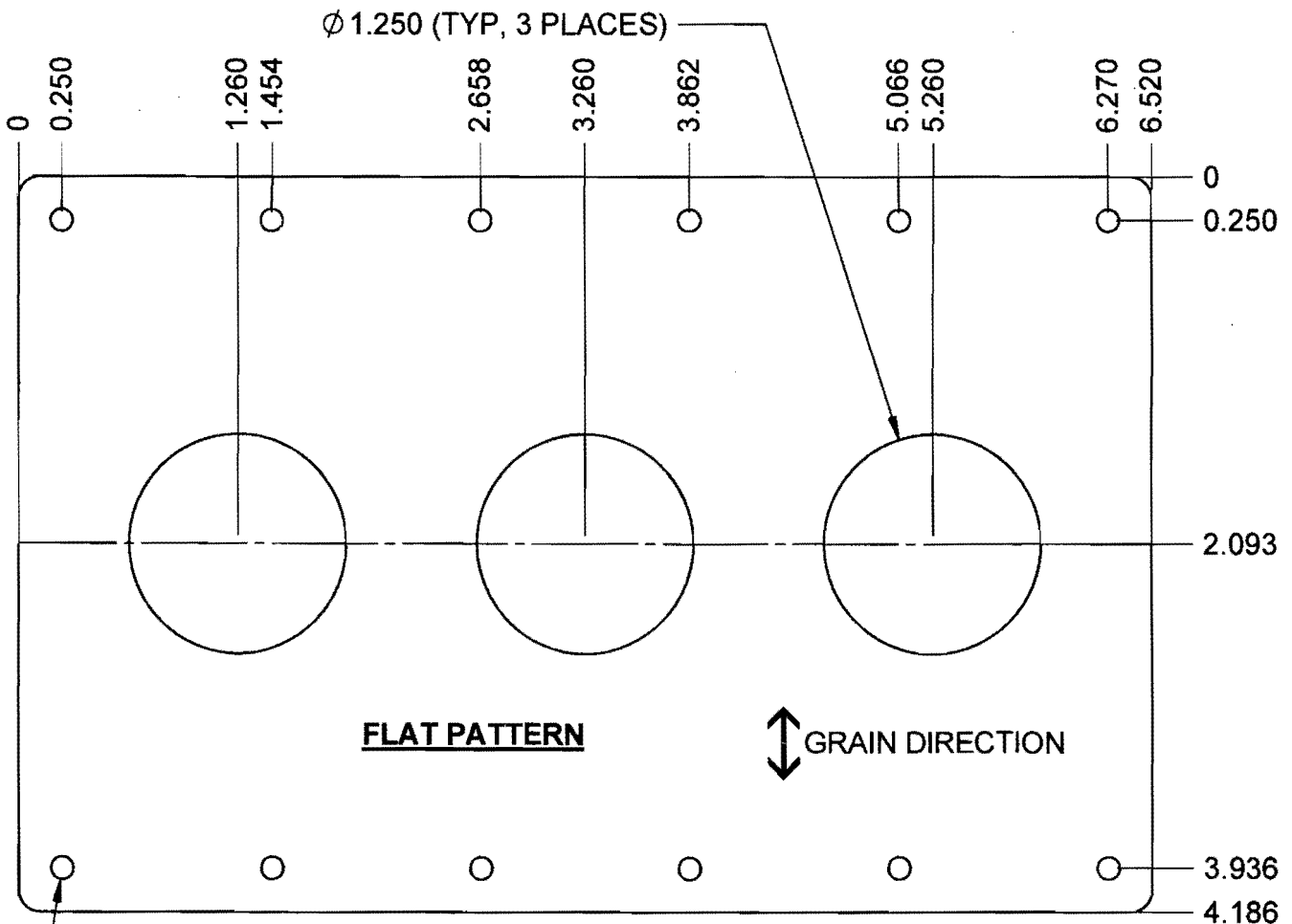
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3065</b>	REV. B SHEET 3 OF 5
DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1

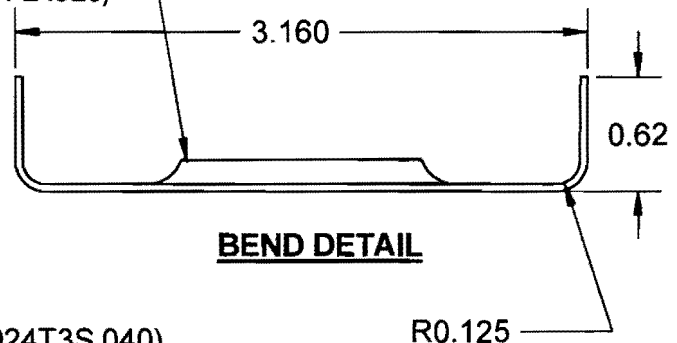


FLANGE AFTER TOWARDS SIDE  
SHOWN USING DT8174 (3 PLACES)

Ø 0.129 (TYP, 12 PLACES)

**RELEASED**

*06.06.20* *[Signature]*



**BEND DETAIL**

**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)  
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

*06.06.20* *[Signature]*

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

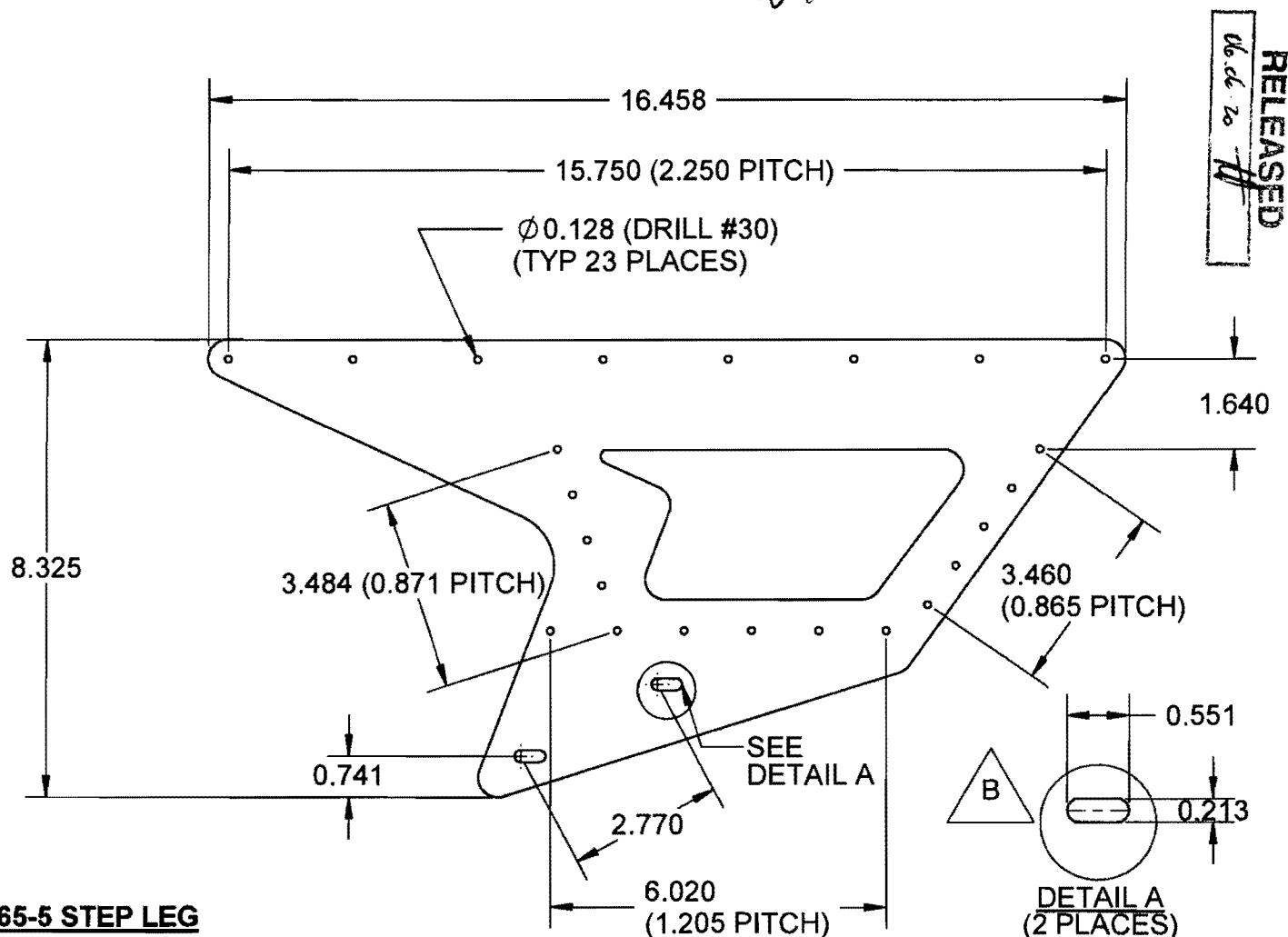
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**DART**

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				HAWKESBURY, ONTARIO, CANADA
CHECKED	PH	APPROVED		DRAWING NO.
				D3065
DATE	06.05.23	TITLE	STEP LEG ASSEMBLY	REV. B
				SHEET 4 OF 5
		SCALE	1:3	

**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRJT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK  
(REF DART SPEC M6061T6S.080)  
OR  
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

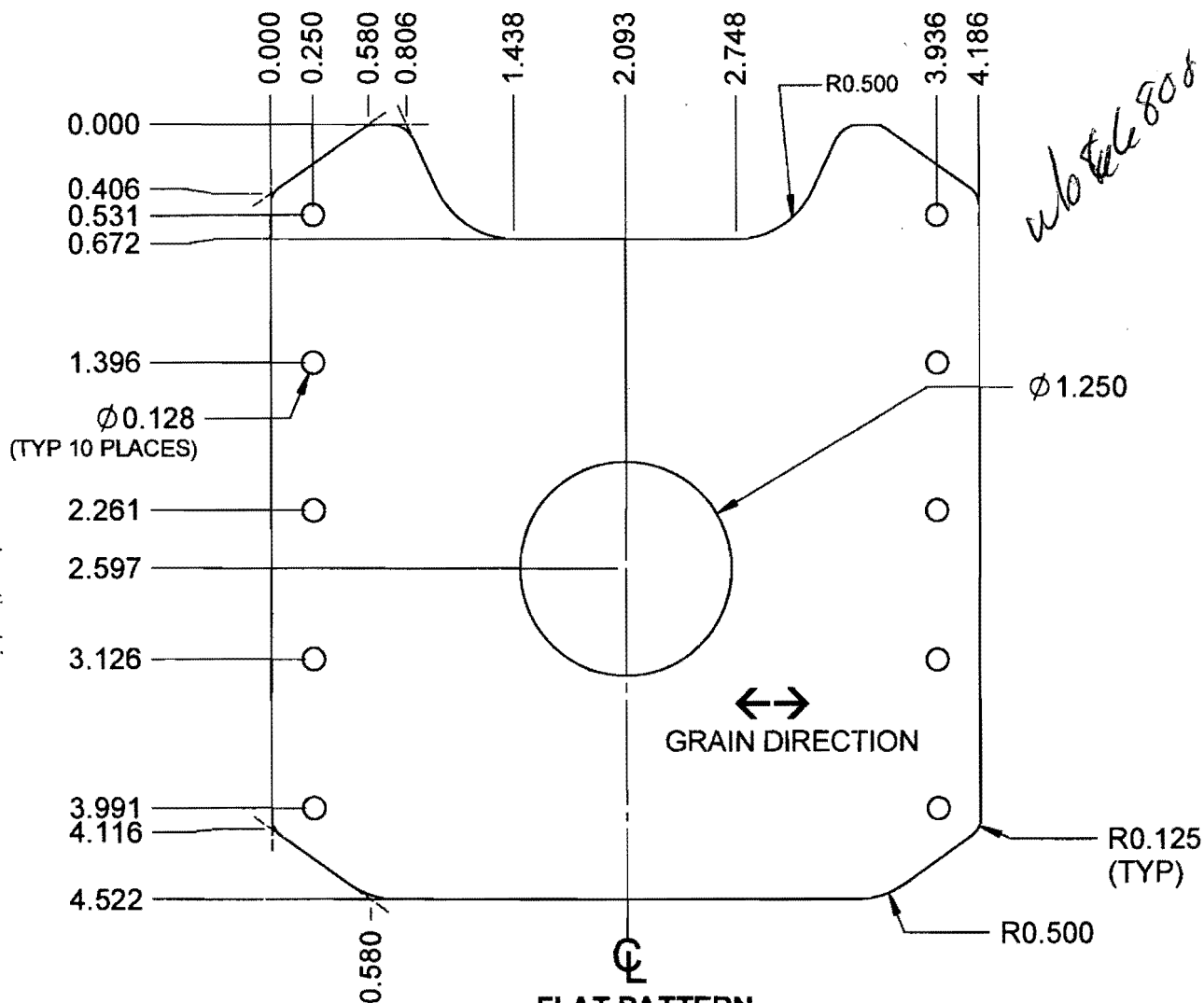
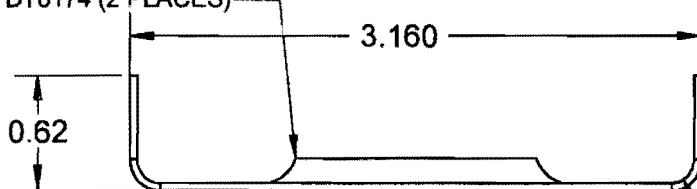
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DATE <b>06.05.23</b>	TITLE <b>STEP LEG ASSEMBLY</b>		SCALE 1:1

**FLAT PATTERN**FLANGE AFTER BENDING TOWARDS  
SIDE SHOWN USING DT8174 (2 PLACES)**BEND DETAIL****RELEASED***[Signature]***D3065-7 STEP SPACER**

- 1) MATERIAL: 2024-T3 (PER QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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